

# Work Order ID 61188

August 11, 2010 7:43:21 AM



Page 1

Item ID: D350-636-012

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube RH

Start Date: 8/11/10 Start Qty: 1.00



Cust Item ID:

Required Date: 8/20/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CY Date: 10/2/11 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2750	Rev F
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100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 005

S 10/08/30

HJ for BG 10-8-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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110

0.00



Skidtubes

0.00

Skidtubes

Skidtubes

## Memo

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside.  
AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500",  
deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade  
fitting

5- Drill fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill  
Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)  
\*\*\*ONLY DRILL ONE SIDE OF FWD SADDLE HOLES USING DT8150\*\*\*

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.  
\*\*\*SECOND SIDE\*\*\*

8- Clecko DT9642 and drill fwd saddle holes on second side, ensure proper  
positioning.

9- Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting  
location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up  
holes for ground handling and detail C to 0.500" (8 holes per side)

10- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to

AWH 10-08-14

DP  
10-8-16

W/O:		WORK ORDER CHANGES					
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Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

0.297".

11-Open up holes of Detail A to 0.297" (total of 2 holes per side)

12-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod batch: ☐

13-Grind welds flush as per Dwg D2750

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

&gt; DD 8-10-16

M114877 BE 8-10-16  
BE 8-10-17

8.06617

8.06617

④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

10-8-17

Hand Finishing

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

10-08-17

Quality Control

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Customer:

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Run Start



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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
	Skidtubes								
Skidtubes									
Skidtubes	<p><b>Memo</b></p> <p>1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.</p> <p>2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.</p> <p>3-Open float holes to .500" (4 per Side)</p> <p>4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)</p> <p>5-Deburr and blow out all chips from inside of tube</p> <p>6-Prepare tube for welding, remove alodine as required.</p> <p>7-Bond web D2739 in place as per QSI 015 A/R <input type="checkbox"/> Sikaflex-291 batch: <u>M115114</u> <input type="checkbox"/> exp. date: <u>11-1-30</u></p> <p>8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 &amp; QSI004 (welding instructions on sheet 9) A/R <input type="checkbox"/> Aluminum Rod batch: <u>M114877</u></p> <p>9- At section AP-AP drill out x-bolt spacer to 0.404"</p> <p>10-Grind welds flush as per Dwg D2750</p> <p>11-Spot face ground handling holes section (total of 4 places per side) as per</p>	0.00							

*DP*  
*10-8-17*

*BE 10/08/13*  
*BE 10/08/18*  
*BE 10/08/24*  
*BE 10/08/24*

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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dwg D2750

12-Debur holes

*BE 10/08/24*

170

QC10- Inspect visual per QSI004- ground welds

0.00

*S 10/08/24*



QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

*S 10/08/24*



QC

Memo

0.00

Quality Control

*QD*

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  HandFinish	Pressure Wash per QSI005 4.3	0.00				1	0		
Hand Finishing	<b>Memo</b> ✓ Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.	0.00	M	10/08/25					
200  Powdercoat	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				1	0		
Powder Coating	<b>Memo</b> START TIME: 1:15pm OVEN TEMPERATURE: 320°F FINISH TIME: 1:45pm	0.00	⇒ M	10/08/25					
210  QC	QC3- Inspect Part Finish	0.00							
Quality Control	<b>Memo</b> Inspect for foreign object per QSI 024	0.00							M 10 08 26 (17)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 	HandFinishing	0.00							
HandFinish	Memo	0.00							
Hand Finishing	Install inserts as per dwg D2750								
230 	HandFinishing	0.00							
HandFinish	Memo	0.00							
Hand Finishing	1-Inspect for Foreign Objects								
	2-Spray inside of tube with "LPS-3" batch: <u>N/A</u>								
	3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>115114</u> EXP DATE: <u>11/01</u>								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>114187</u>								
	5-Coat all exposed fasteners with "LPS Procyon" batch: <u>114596</u>								

ml 10 08 26 ①

ml 10 08 26 ①

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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240

QC5- Inspect part completeness to step on W/O

0.00

S 10/08/27



QC

Memo

0.00

(X)

Quality Control

250

Pick Kit

0.00



Packaging

Memo

0.00

P 10/14/30

Packaging

260

QC4- 100% Inspect kits for completeness

0.00

S 10/08/30



QC

Memo

0.00

(X)

Quality Control

W/O:		WORK ORDER CHANGES					
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Run Start

Stop

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270

0.00



Packaging

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-012

MCH

280

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

C/L 10/8/31

10/08/31

C/L 10/8/31

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# Picklist Print

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Page 1

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Parent Item: D350-636-012

Parent Item Name: Skidtube RH



Start Date: 8/11/10

Required Date: 8/20/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev: J 06-03-29 As per Rev D EC  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC  
 IPP Rev: M 08-04-22 update steps 4,13 DD verified by: EC  
 IPP Rev: N 08-09-23 revF as per dwg DD verified by: ec IPP Rev: O  
 10.06.22 revise seq110 DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS4-1032-225 		Purchased	No			220	Each	5,945.000	38	38			
Insert													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				PK011		5945							
				110768		5945							
AN3C5A 		Purchased	No			230	Each	1,464.000	34	34			
Bolt													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST350		1454							
				114330		11							
				115015		743							
				115108		300							
				115316		300							
				115371		100							
				ST351		10							
				113121		10							
AN3C6A 		Purchased	No			230	Each	425.0000	4	4			
BOLT													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST351		425							
				111982		425							

MM 10-08-26

MM 10-08-26

MM 10-08-26

# Picklist Print

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Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/11/10

Required Date: 8/20/10

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

177.0000

4

4



BOLT

Location

Loc Qty

Loc Code

FG

2

103964

2

ST344

175

111649

2

114653

1

114784

47

114941

75

115030

50

*mm 10.08.26*

AN8C21A

Purchased

No

250

Each

57.0000

2

2



BOLT

Location

Loc Qty

Loc Code

ST345

57

113558

17

114653

40

*114653*

AN8C35A

Purchased

No

230

Each

53.0000

1

1



BOLT

Location

Loc Qty

Loc Code

FP

1

110847

1

ST346

52

114442

27

115188

25

*mm 10.08.26*

# Picklist Print

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Start Date: 8/11/10

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Start Qty: 1.00

Required Qty: 1.00

AN960C10L NAS1149C0332 Purchased No

230 Each 29.0000 38 38



washer

B# 115000

Location

Loc Qty

Loc Code

ST245

29

107534

29

AN960C816L Purchased No

230 Each 21.0000 1 1



WASHER

Location

Loc Qty

Loc Code

ST348

21

110584

18

111424

3

AN960C816L Purchased No

250 Each 21.0000 1 2



WASHER

Location

Loc Qty

Loc Code

ST348

21

110584

18

111424

3

D2741 Manufactured No

250 Each 21.0000 1 1



Blade, 350 Skidtube

Location

Loc Qty

Loc Code

ST466

21

55905

1

57949

20

57949

August 11, 2010 7:43:20 AM

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Work Order ID: 61188

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/11/10

Required Date: 8/20/10

Start Qty: 1.00

Required Qty: 1.00

D2745      Manufactured      No      230      Each      169.0000      8      8



Bushing

Location	Loc Qty	Loc Code
ST023	169	
52311	5	
59112	164	

*ml* 10.08.26

D3488-042      Manufactured      No      230      Each      17.0000      1      1



Blade Fitting Assembly, RH

Location	Loc Qty	Loc Code
FP008	17	
53918	5	
59643	12	

*ml* 10.08.26

D3492-041      Manufactured      No      230      Each      93.0000      8      8



Plug Assembly

Location	Loc Qty	Loc Code
FP013	93	
59114	24	
59420	69	

*ml* 10.08.26

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Work Order ID: 61188

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/11/10

Required Date: 8/20/10

Start Qty: 1.00

Required Qty: 1.00

D3492-043 Manufactured No

230

Each

51.0000

8

8



Plug Assembly

B# 61207

Location

Loc Qty

Loc Code

FP

2

54682

2

FP013

49

59117

1

59190

4

59421

14

60712

30

MT 10.08.26

D3493-1 Manufactured No

250

Each

48.0000

2

2



Washer

Location

Loc Qty

Loc Code

ST065

48

59127

18

60873

30

~~59127~~  
60873

D3532-1 Manufactured No

250

Each

31.0000

2

2



Spacer

Location

Loc Qty

Loc Code

ST068

31

59426

9

60510

22

60510

D3535-25 Manufactured No

230

Each

24.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP18

24

59623

24

MT 10.08.26

August 11, 2010 7:43:20 AM

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Page 5

# Picklist Print

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Work Order ID: 61188

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/11/10

Required Date: 8/20/10

Start Qty: 1.00

Required Qty: 1.00

D3536-25      Manufactured      No      230      Each      29.0000      1      1



Gasket

Location	Loc Qty	Loc Code
FP12	29	
58820	5	
59625	24	

FP12

29

58820

5

59625

24

D3537-1      Manufactured      No      230      Each      55.0000      3      3



Wearpad

Location	Loc Qty	Loc Code
FP	1	
55465	1	
FP17	54	
57713	3	
59593	3	
60192	48	

FP

1

55465

1

FP17

54

57713

3

59593

3

60192

48

D3631-1      Manufactured      No      230      Each      571.0000      8      8



Washer

Location	Loc Qty	Loc Code
ST072	297	
60755	297	
ST076	274	
52693	206	
54388	68	

ST072

297

60755

297

ST076

274

52693

206

54388

68

B# 60491

*M/ 10-08-26*

*M/ 10-08-26*

*M/ 10-08-26*

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Work Order ID: 61188

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/11/10

Required Date: 8/20/10

Start Qty: 1.00

Required Qty: 1.00

D3672-1 Manufactured No 230 Each 1,011.000 4 4



Phenolic Washer

Location Loc Qty Loc Code

ST077 993

51674 5

52505 988

ST117 18

34470 18



*mm 10-08-26*

D3672-13 Purchased No 250 Each 842.0000 2 2



Phenolic Washer

Location Loc Qty Loc Code

ST077 842

54363 842



*54363*

D3791-1 Manufactured No 230 Each 20.0000 1 1



Wearplate

Location Loc Qty Loc Code

FP17 20

58573 11

59626 9



*mm 10.08.26*

D3793-1 Manufactured No 230 Each 15.0000 1 1



Wearshoe

Location Loc Qty Loc Code

FP18 15

59151 2

59630 13



*mm 10.08.26*

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Work Order ID: 61188

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/11/10

Required Date: 8/20/10

Start Qty: 1.00

Required Qty: 1.00

D3793-3      Manufactured      No      230      Each      13.0000      1      1



Wearshoe

Location      Loc Qty      Loc Code

FP18      12

59631      12

FP19      1

57947      1

*ml 10.08.26*

D3794-1      Manufactured      No      230      Each      19.0000      1      1



Gasket

Location      Loc Qty      Loc Code

FP010      19

57942      18

59627      1

*ml 10.08.26*

D3794-3      Manufactured      No      230      Each      24.0000      1      1



Gasket

Location      Loc Qty      Loc Code

FP10      12

60826      12

FP18      12

56066      11

59153      1

*ml 10.08.26*

MS21043-6      Purchased      No      230      Each      726.0000      4      4



NUT

Location      Loc Qty      Loc Code

ST301      726

112314      726

*ml 10.08.26*

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# Picklist Print

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Work Order ID: 61188



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 8/11/10

Required Date: 8/20/10

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

56.0000

1

1



NUT

Location

Loc Qty

Loc Code

ST303

56

113845

7

114934

49

*MM 10.08.26*

MS21083C8

Purchased

No

250

Each

56.0000

1

2



NUT

Location

Loc Qty

Loc Code

ST303

56

113845

7

114934

49

*114934*

NAS1611-010

Purchased

No

230

Each

267.0000

8

8



O-RING

Location

Loc Qty

Loc Code

FP

267

110715

100

110915

167

*MM 10.08.26*

NAS1611-013

Purchased

No

230

Each

67.0000

8

8



O-RING

Location

Loc Qty

Loc Code

FP

67

114451

51

114496

16

*MM 10.08.26*

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Work Order ID: 61188

Parent Item: D350-636-012

Parent Item Name: Skidtube RH



Start Date: 8/11/10

Required Date: 8/20/10

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110

Each

16.0000

1

1



Extrusion Bent

Location

Loc Qty

Loc Code

LG

16

59410

16

AWM 10-28-14 \*

D2744

Manufactured No

110

Each

35.0000

1

1



Cap

Location

Loc Qty

Loc Code

LG

35

59198

35

BE 10-08-16

D2739

Manufactured No

160

Each

0.0000

1

1



350 I Beam

B61256

①

DP 10-8-17

D2743

Manufactured No

160

Each

299.0000

8

8



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

299

50281

10

57953

2

59111

287

8 BE 10-8-18

D3490-3

Manufactured No

160

Each

54.0000

4

4



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

54

59229

14

60294

40

4 BE 10-8-18

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# Picklist Print

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Work Order ID: 61188



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 8/11/10

Required Date: 8/20/10

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

19.0000

4

4



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

19

59424

19

B 6/2/7

x4

BE 10/08/18

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

## GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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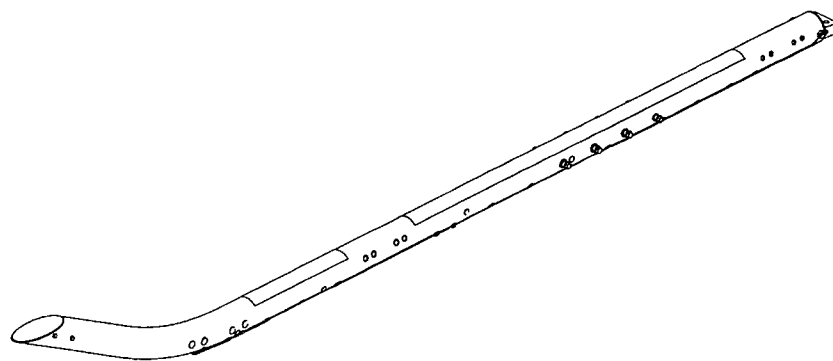
C2108/11

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6/27/22

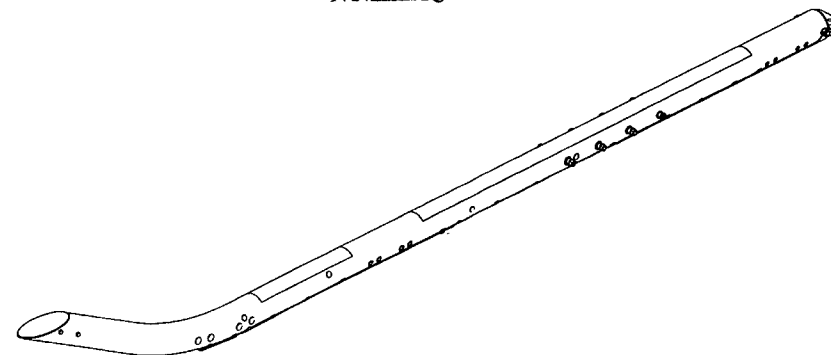
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL), WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 09-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PC		
DRAWN	RM		
CHECKED	AS		
MFG. APPR.	AM		
DE APPR.	AM		
DATE	08.07.16		

DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWING NO. D2750	REV. F SHEET 1 OF 11
TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
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D2750-041 350 SKIDTUBE ASSEMBLY, LH

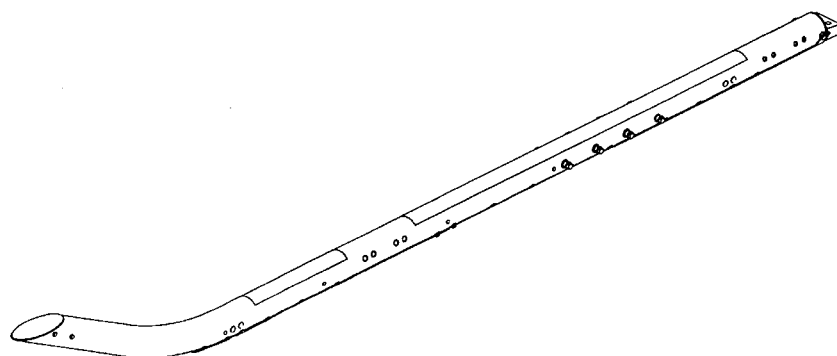


D2750-042 350 SKIDTUBE ASSEMBLY, RH

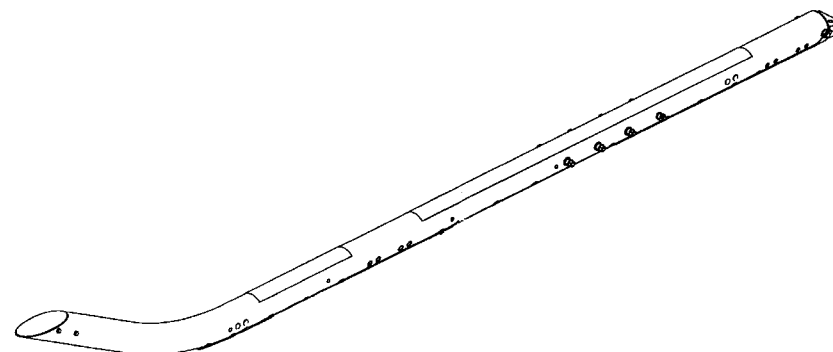
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MFG. APPR.	AM	D2750	SHEET 2 OF 11
APPROVED	AM	TITLE	SCALE
DE APPR.	AM	350 SKIDTUBE ASSEMBLY	NTS
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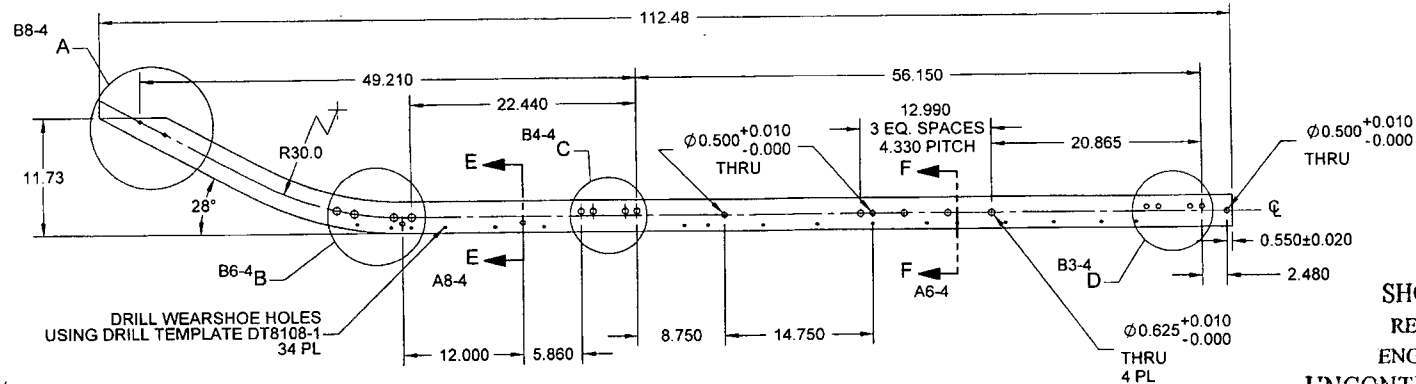
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D2750-044 350 SKIDTUBE ASSEMBLY, RH

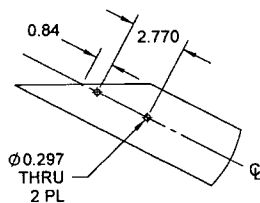
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DESIGN	PH	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO. <b>D2750</b>	REV. F
MFG. APPR.	PH	SHEET 3 OF 11	
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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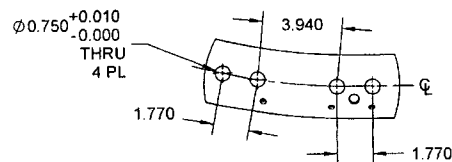


**D2750-1 LH SKIDTUBE**

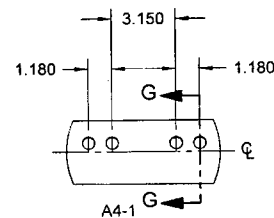
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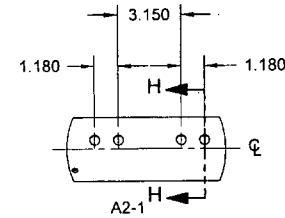
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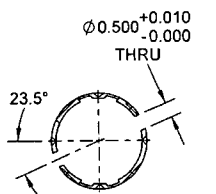
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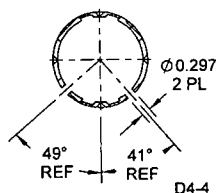
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SCALE 2X



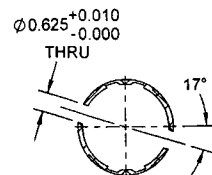
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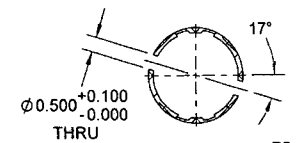
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



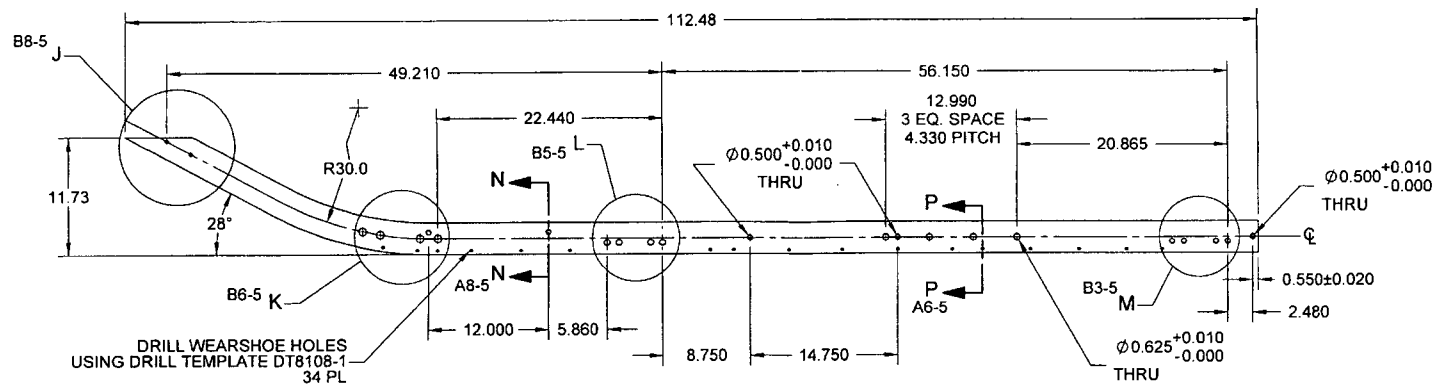
**SECTION G-G**  
SCALE 3X, 4 PL



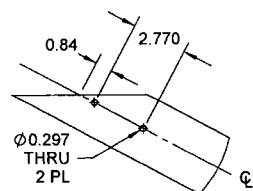
**SECTION H-H**  
SCALE 3X, 4 PL

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MFG. APPR.		<b>D2750</b>	SHEET 4 OF 11
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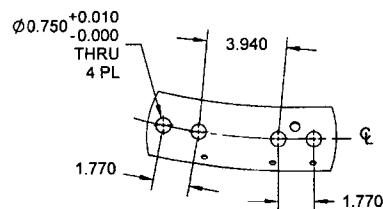
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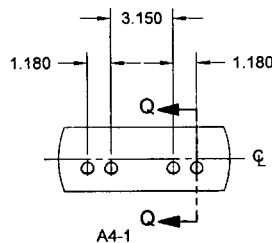
**D2750-2 RH SKIDTUBE**



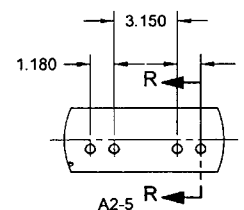
**DETAIL J**  
SCALE 2X



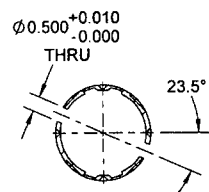
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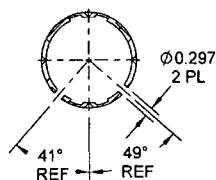
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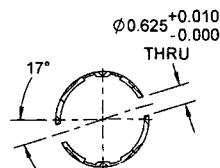
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SCALE 2X



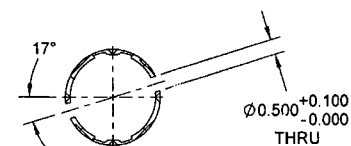
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

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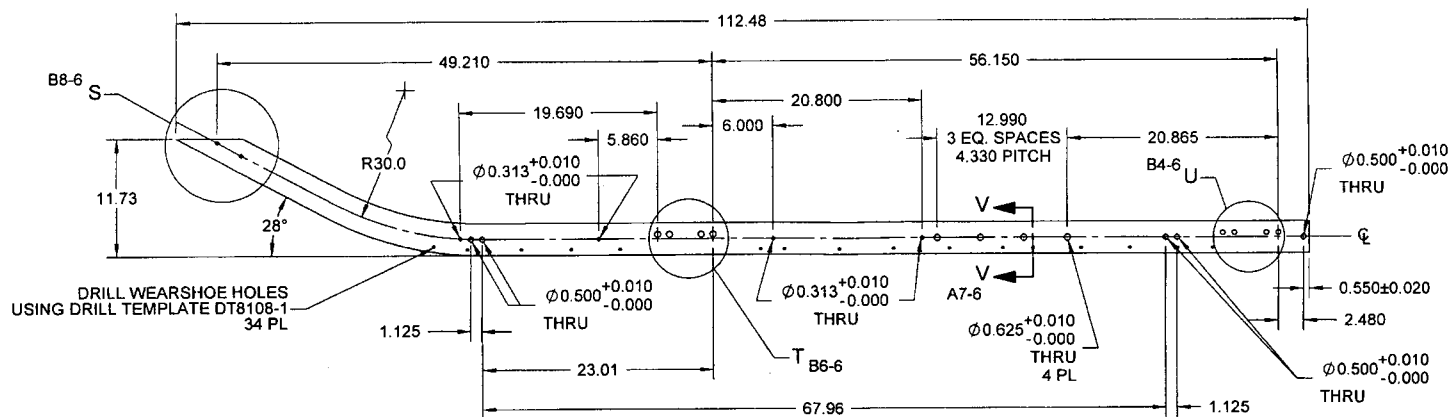
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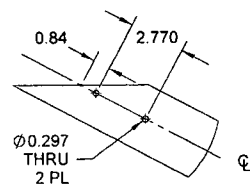
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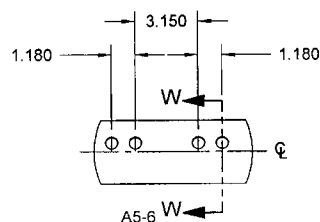
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**D2750-3 LH SKIDTUBE**

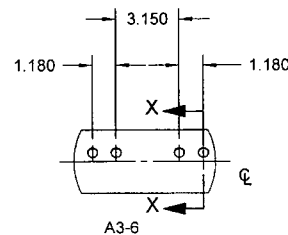
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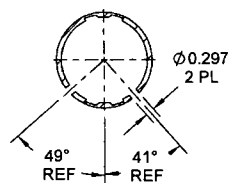
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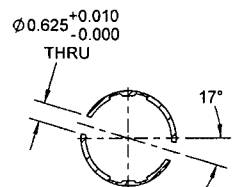
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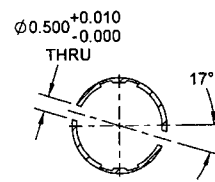
**DETAIL U**  
SCALE 2X



**SECTION V-V**  
SCALE 3X, 17 PL



**SECTION W-W**  
SCALE 3X, 4 PL



**SECTION X-X**  
SCALE 3X, 4 PL

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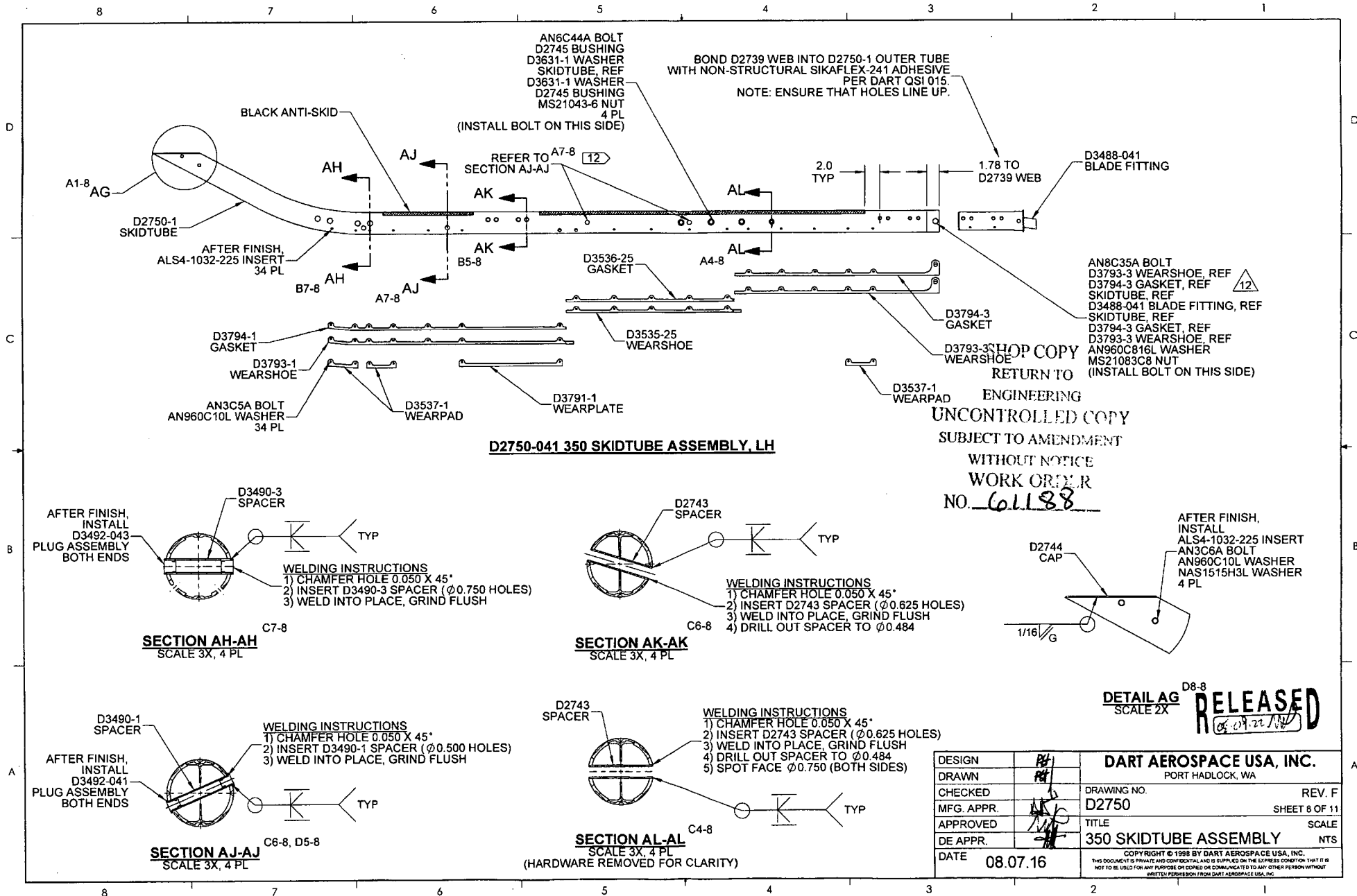
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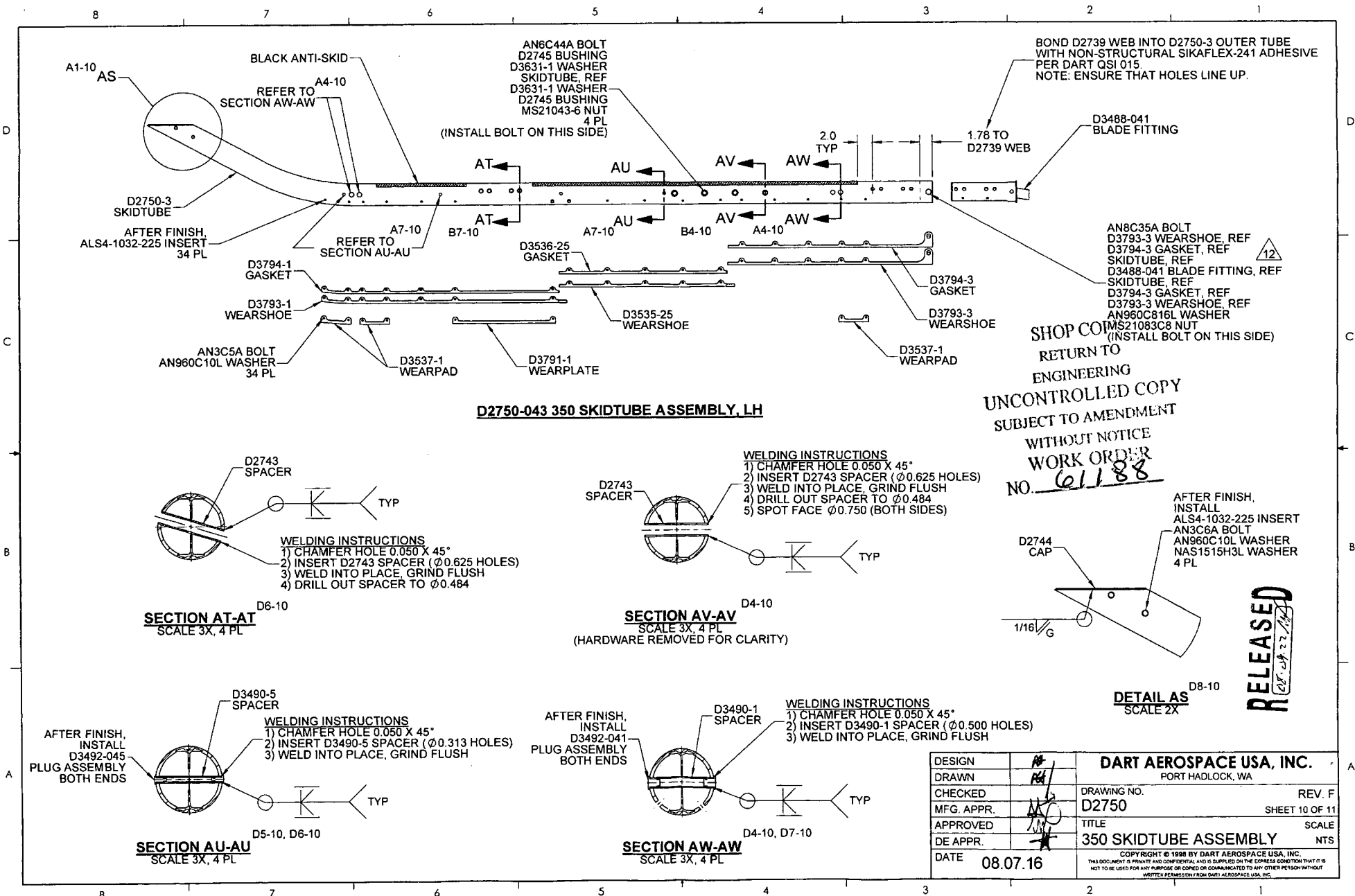


DESIGN	<i>PH</i>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA  DRAWING NO. <b>D2750</b>  TITLE <b>350 SKIDTOBE ASSEMBLY</b>  COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT PERMISSION. DESIGN, DRAWING, ORIGIN, AND INVENTION ARE RESERVED.</small>	REV. 1
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APPROVED	<i>PH</i>		
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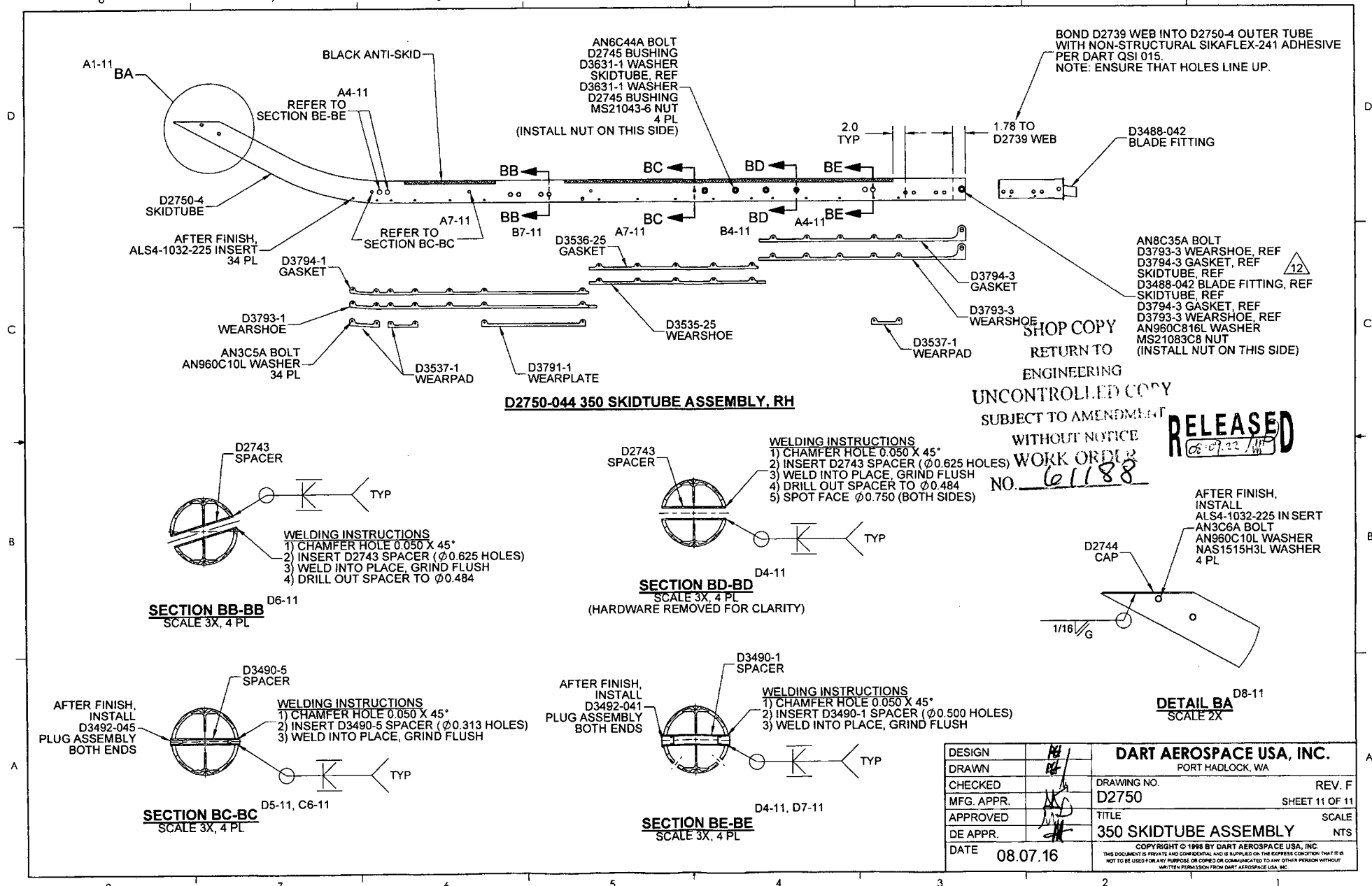
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NO. 236

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 60988  
Part number: D350-636-Q12  
Description: 350 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual:  
Penetration:

pass[☒] fail[ ]  
pass[☒] fail[ ]

UNACCEPTABLE

Cracks:  
Undercut:  
Pin holes:  
Overlap (cold lap)  
Porosity (surface):  
Coloration:

pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]

Qualifier [Signature] Date of Test Coupon 10.08.12

Welder [Signature] Date of Test Coupon 10.08.12

The above named individual is qualified in accordance with AWS D17.1.2001 to weld